

Work Order ID 131433

Wednesday, April 08, 2015 1:05:16 PM

131433

Page 1

Item ID: D3651-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Base Assembly
 Start Date: 4/8/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/8/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 1504-08 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3651	Rev B								APR 15 2015
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110		0.00							
110	Small Fab								APR 15 2015
Small Fab	Memo	0.00							
Small Fab	1-Assemble as per dwg D36512- Seal all mating surfaces and gaps using Proseal 700 fire wall sealant as per dwg D3651Batch: <u>17132021</u> 3-install D3651-1 using 3M high per formance contact adhesive 1357 as per dwg D3651Batch: <u>17102603</u> <u>17127394</u>								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									APR 15 2015
QC	Memo	0.00							
Quality Control									

DAS
30
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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130	Identify as per dwg & Stock Location: <u>GA</u>	0.00		DAS					
130				30					
Packaging	Memo	0.00		9-89					APR 15 2015
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 15-04-16

MF
15-4-16

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Parent Item: D3651-041

D3651-041

Parent Item Name: Aft Base Assembly

Start Date: 4/8/2015

Required Date: 4/8/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPP Rev:B ECN 1113P 08-01-22 DD verified by: EC
IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
CR3523-4-02		Purchased	No			100	Each	593.0000	58	58			

CR3523-4-02

RIVET

**

FF APR 16 2015

Location	Loc Qty	Loc Code
GA	126	
m130415	126	
ST318	467	
m130415	67	
m131340	200	
m131803	200	

50

D3651-043

Manufactured No

110 Each 5.0000 1 1

D3651-043

Flange Weldment

**

FF

Location	Loc Qty	Loc Code
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ST227 5

126823 5

D3651-1

Manufactured No

110 Each 7.0000 1 1

D3651-1

Gasket

**

FF

Location	Loc Qty	Loc Code
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ST227 7

126523 5

95811 2

1

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Page 2

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Parent Item: D3651-041

D3651-041

Parent Item Name: Aft Base Assembly

Start Date: 4/8/2015

Required Date: 4/8/2015

Start Qty: 1.00

Required Qty: 1.00

D3651-11
 ✓ ***D3651-11***
 Gasket
 Manufactured No 110 Each 4.0000 1 1
 ** FF APR 16 2015

Location Loc Qty Loc Code

ST227 4
 128231 4

D3651-13
D3651-13
 Outside Doubler
 Manufactured No 110 Each 6.0000 1 1
 ** FF

Location Loc Qty Loc Code

GA 2
 94690 1
 95404 1
 ST227A 4
 128232 4
~~128233~~

D3651-9
 ✓ ***D3651-9***
 Inside Doubler
 Manufactured No 110 Each 5.0000 1 1
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Location Loc Qty Loc Code

ST227A 5
 127454 1
 128233 4

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